

Work Order ID 75117

75117

Page 1

October 17, 2011 2:35:48 PM

Item ID: D2661-2

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 19/10/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 29/10/2011 Req'd Qty: 10.00

10

Customer:

Reference:

11.10.17

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2661	Rev D								

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number
MACHINE AS PER DWG AND FOLIO FB071

FOLIO REV: AA
DWG REV: B

SL/AMK 11/11/09

10 0

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

SL/AMK 11/11/09

10 0

Work Order ID 75117

October 17, 2011 2:35:48 PM

75117

Page 2

Item ID: D2661-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, RH Fwd Aft Out 206
 Start Date: 19/10/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 29/10/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	SL/ML 11/11/09			10	0		
130 *130* QC Quality Control	QCS- Inspect parts - second check Memo	0.00 0.00	B.A 11/11/10			10	0		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							AG M-11/11/10

Work Order ID 75117

October 17, 2011 2:35:48 PM

75117

Page 3

Item ID: D2661-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, RH Fwd Aft Out 206
Start Date: 19/10/2011 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 29/10/2011 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Adum	0.00							
150	Powdercoat	0.00							
Powder Coating	Memo	0.00							
	START TIME: 8-10	OVEN TEMPERATURE:							
	FINISH TIME: 8-40								
160	QC3- Inspect Part Finish	0.00							
160	QC	0.00							
Quality Control	Memo	0.00							
170	Identify as per dwg & Stock Location	0.00							
170	Packaging	0.00							
Packaging	Memo	0.00							

10X Ø M-11/11/11

10 BR 11-11-11

Sp 11-11-14

M 118439

3200F

8-10

8-40

S476

Work Order ID 75117

October 17, 2011 2:35:48 PM

75117

Page 4

Item ID: D2661-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Saddle, RH Fwd Aft Out 206

Stop

NS2

Start Date: 19/10/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 29/10/2011 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21 - Final Inspection - Work Order Release

0.00


180

QC

Memo

0.00

Quality Control

11/11/15 

211-11-04
(10)

Picklist Print

October 17, 2011 2:35:48 PM

Page 1

Work Order ID: 75117

Parent Item: D2661-2

Parent Item Name: Saddle, RH Fwd Aff Out 206

Start Date: 19/10/2011

Required Date: 29/10/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house processEC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 Saddle Billet, 7075		Manufactured	No			100	Each	81.0000	1	10			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT040	68	
72226	8	
73775	60	
MAT44	13	
72226	2	
73769	11	

74680 x 10

mk 11/10/26

DART AEROSPACE LTD	Work Order: 75117
Description: 206 Saddle, Outboard, Right side	Part Number: D2661-2
Inspection Dwg: D2661 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By 5	Date
A	0.100	0.140		.126	.123	.127	.127	.127	
B	0.100	0.140		.120	.120	.122	.122	.122	
C	1.125	1.145		1.138	1.139	1.138	1.138	1.137	
D	0.615	0.685		.685	.685	.685	.680	.680	
E	0.240	0.260		.250	.250	.249	.249	.250	
F	1.313	1.343		1.326	1.326	1.326	1.326	1.326	
G	0.210	0.230		.223	.224	.224	.223	.223	
H	0.100	0.180		.140	.140	.140	.135	.135	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.578	1.579	1.577	1.573	1.576	
K	0.235	0.240		.238	.237	.237	.237	.237	
L	0.100	0.120		.108	.112	.111	.110	.110	
M	0.990	1.010		1.000	1.000	1.000	1.000	1.000	
N	0.510	0.515		.512	.512	.512	.512	.512	
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		.313	.313	.314	.314	.314	
S	0.315	0.322		.316	.316	.316	.316	.316	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		.797	.797	.795	.796	.795	
W	0.540	0.560		.549	.549	.550	.545	.545	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		.257	.257	.257	.257	.257	
Z	0.912	0.932		.922	.922	.921	.921	.924	
AA	0.490	0.510		.498	.496	.498	.499	.500	
AB	0.178	0.198		.188	.188	.188	.188	.188	
AC									
AD									
AE									
AF									
Accept/Reject									

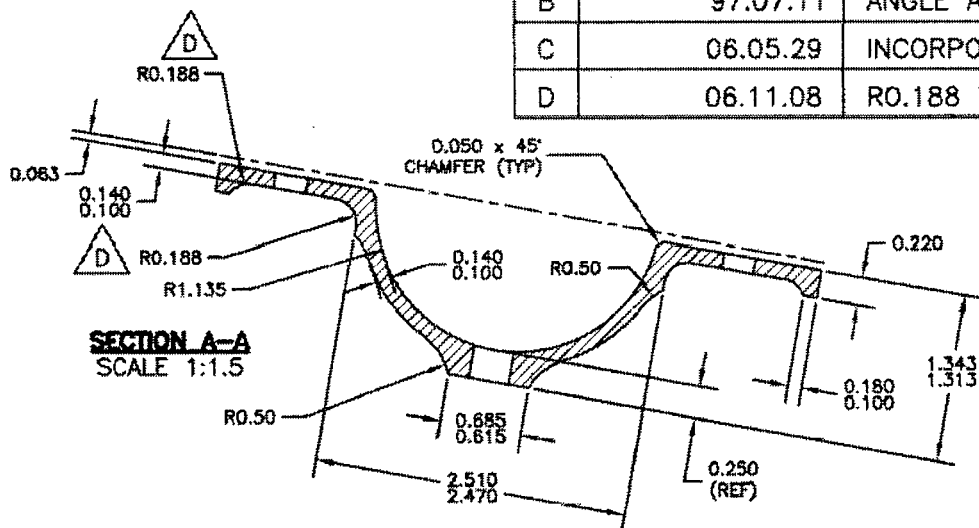
Measured by: <i>[Signature]</i>
Date: 11-11-08 11/11/09

Audited by: <i>[Signature]</i>
Date: 11/11/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat, Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.10.13	Dimensions C and F revised	KJ	<i>[Signature]</i>



DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2661	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE OUTSIDE	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

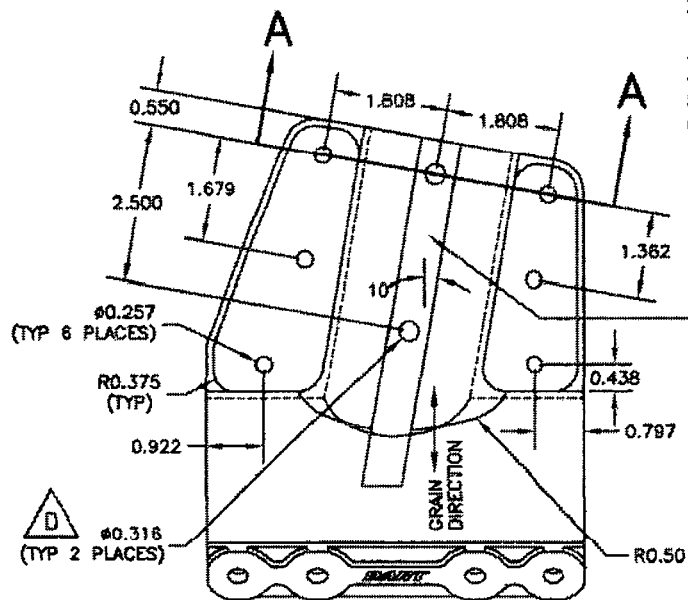


RELEASED

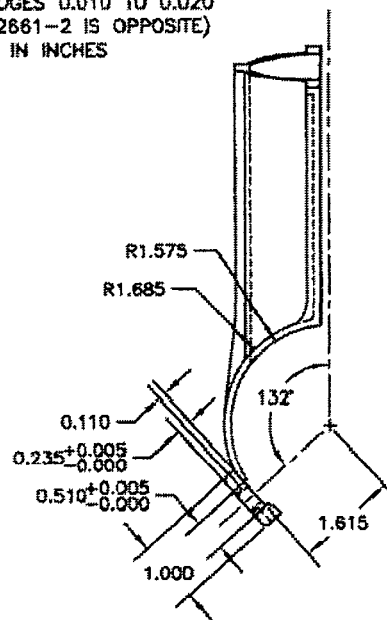
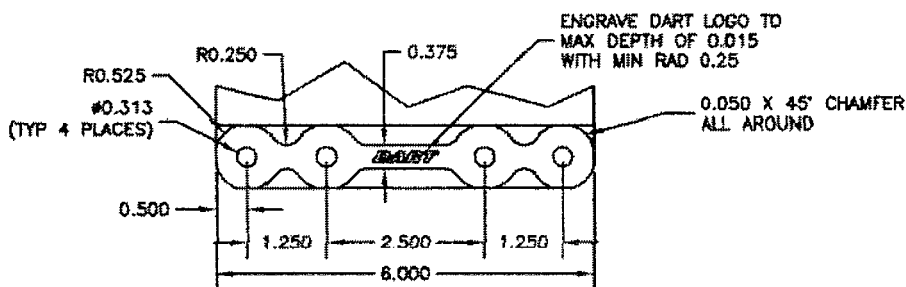
07.02.12 #

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2661-1 SHOWN (D2661-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010



D2661-1 SADDLE OUTSIDE

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

DART AEROSPACE LTD	Work Order: 75117
Description: 206 Saddle, Outboard, Right side	Part Number: D2661-2
Inspection Dwg: D2661 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	A6	A7	A8	A9	By ID	Date	
A	0.100	0.140		.127	.126	.127	.128	.127		
B	0.100	0.140		.124	.124	.125	.124	.125		
C	1.125	1.145		1.139	1.137	1.139	1.139	1.139		
D	0.615	0.685		.680	.680	.680	.675	.275		
E	0.240	0.260		.249	.249	.247	.249	.249		
F	1.313	1.343		1.327	1.327	1.327	1.327	1.327		
G	0.210	0.230		.225	.225	.225	.225	.225		
H	0.100	0.180		.135	.135	.135	.135	.135		
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490		
J	1.565	1.585		1.577	1.5745	1.576	1.577	1.577		
K	0.235	0.240		.237	.237	.237	.237	.237		
L	0.100	0.120		.111	.110	.110	.111	.111		
M	0.990	1.010		1.000	1.000	1.000	1.000	1.000		
N	0.510	0.515		.511	.511	.511	.511	.511		
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314	.314		
S	0.315	0.322		.316	.316	.316	.316	.316		
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362		
V	0.787	0.807		.795	.797	.797	.795	.795		
W	0.540	0.560		.545	.546	.546	.546	.545		
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258	.258		
Z	0.912	0.932		.921	.920	.922	.922	.923		
AA	0.490	0.510		.498	.500	.498	.502	.501		
AB	0.178	0.198		.188	.188	.188	.188	.188		
AC										
AD										
AE										
AF										
Accept/Reject										

Measured by: <i>amf</i>
Date: 11/11/09

Audited by: <i>B.A.</i>
Date: 11/11/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.10.13	Dimensions C and F revised	KJ	<i>[Signature]</i>

